Work Order ID 56246 Wednesday, February 17, 2010 11:03:10 AM Item ID: D105-645-011 Accept Setup Start **Revision ID:** Stop Item Name: Bearpaw Start Qty: 4.00 **Start Date:** 2/18/2010 **Cust Item ID:** Req'd Qty: 4.00 Required Date: 3/4/2010 **Customer:** Reference: Run Start **Process Plan: Tooling:** Approvals: Date: Date: Stop QC: SPC (Y/N): Date: Date: Operation Sequence ID/ Set Up/ Draw Reject Draw Plan Accept Reject Insp. Work Center ID Description Number Rev. Qty Qty **Run Hours** Code Number Stamp **Draw Nbr Revision Nbr** D2421 Rev F2 100 0.00 DOCUMENT CONTROL 0.00 Memo Photocopy bluefile and create labels per PPP D105-645-011 CHG003 Document Control 160 Pick Kit 0.00

Packaging

Packaging

Memo

0.00

170

QC

Quality Control

QC4-100% Inspect kits for completeness

0.00

Memo

0.00

10-3-5 @ St

Page 1

W/O:			W	ORK ORDER CHANG	ES	-		•	7
DATE STEP		PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ /	A:	Date:	
	Resolution: Disposition: C								
NCR:		1	WORK ORD	DER NON-CONFORMA	ANCE (NCF	1)			
DATE	STEP	Description of NC Corrective Action			Section B		ation	Approval	Approval
	0.21	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
									-

Page 2

Item ID:

D105-645-011

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Bearpaw

2/18/2010

Wednesday, February 17, 2010 11:03:10 AM

Start Qty: 4.00

Operation

Description

Packaging

Required Date: 3/4/2010

Req'd Qty: 4.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Run

Start

Stop

Reject

Number



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Plan

Code

Qty

Reject Accept

Insp.

Stamp

Sequence ID/ **Work Center ID**

Packaging

Packaging

Identify and pack for shipping as per PPP D105-645-011

Location:

Memo

190

QC21- Final Inspection - Work Order Release

0.00



QC Quality Control Memo

0.00

10/04/06HJ

W/O:			W	ORK ORDER CHANG	ES		•	3
DATE	STEP	PRO	CEDURE CH	NGE	Ву	Date Qty	Approval Chief Eng /* Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes N	lo DQA:	Date: _	
	R	esolution:					Date: _	
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DATE	STEP	Description of NC	Description of NC Correct Initial A		on B Sign &		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
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Picklist Print Wednesday, February 17, 2010 11:03:10 AM Work Order ID: 56246 Parent Item: D105-645-011 Parent Item Name: Bearpaw **Start Date: 2/18/2010** Required Date: 3/4/2010 Comments: IPP Rev:A New Issue 07-01-03 JLMCIPP Rev:B New Manufacturing Start Qty: 4.00 Required Qty: 4.00 Method 08-11-04 Verified By:EC Component Item ID/ Replacement Mfg/ Primary Route Last Unit of Qty on Remaining **Qty** Item ID Item Name Purch Item Location Location Seq ID Measure Hand Qty To Pick Issued Manufactured No 170 Each 0.0000 8.0000 D2182B0608 / 1/1@ 6.00" Manufactured 170 16.0000 Each 0.0000 Clamp Cushion D2519 36.0000 Manufactured 170 Each

Manufactured

No

				1.0
Warehouse Location	Loc Oty	Loc Code		B 56 763 10× Co 143/3
Main Warehouse	, ₃₆			
43842	36			16
	170 Each	50.0000	32.0000	10-35 B56189 S
Warahausa	106			

Page 1

Status

Date

Issued

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST017	50		
52745	50		22

·									
W/O:			WO	RK ORDER CHANG	ES			1	,
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng /' Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cated	lorv:	NCR: Yes	No DO	A :	Date:	
Resolution: Disposition:									
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR	1)		1 (100) 100	
DATE	STEP	Description of NC Corrective Action			Section B Ve			Approval	Approval
	JILF	Section A	Initial Chief Eng			Sign & Section C		Chief Eng	QC Inspector
									
						1		[ŀ

Picklist Print

Page 2

Wednesday, February 17, 2010 11:03:10 AM

Work Order ID: 56246

Parent Item:

Comments:

D105-645-011

Parent Item Name:

Bearpaw



Start Date: 2/18/2010

Required Date: 3/4/2010

Start Oty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Method 08-11-04 Verified By:EC

Purch Purchased

Manufactured

Primary Item Location No

IPP Rev:A New Issue 07-01-03 JLMCIPP Rev:B New Manufacturing

Last Location

Route Seq ID 170

Unit of Measure Each

Qty on Hand 231.0000 32.0000

Remaining Qty Qty To Pick Issued

Date Issued

M114108 10.3.5 \$

Status

AN4-15A X

Warehouse Loc Qty Loc Code

Main Warehouse ST113121

Location

113538 113840 170

6 25 200

Each

231

291.0000 32.0000



Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	241		
55602	241		32
Main Warehouse			
ST010	40		
52644	29		
55443	11		
Main Warehouse			
ST10	10		
54850	10		

MRS114900 463 2 OSI GIT

Purchased

No

No

170

0.0000 Each

32.0000

M113706 10-3-5 8

Washer

W/O:	•		\\\C	DK OPPED OUANO		<u> </u>			
W/O:			WC	RK ORDER CHANG	ES .				,
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	Re:	solution:						Date:	
NCR:		· ·	WORK ORDE	ER NON-CONFORMA	NCE (NCR	(1)			
DATE	STEP	Description of NC Corrective Action			Section B		ation	Approval	Approval
	J.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	on C	Chief Eng	QC Inspector
									-
		**							
•									

Wednesday, February 17, 2010 11:03:10 AM

Work Order ID: 56246

Parent Item:

D105-645-011

Parent Item Name:

Bearpaw

Comments:

IPP Rev:A New Issue 07-01-03 JLMCIPP Rev:B New Manufacturing

Method 08-11-04 Verified By:EC

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 4.00

Required Qty: 4.00

Date

Issued

Component Item ID/ Item Name

MS21042L4

Replacement Mfg/ Item ID

Purch Purchased

Primary Bin Location Item No

Last Location

Route Seq ID 170

Unit of Measure Each

Qty on Hand 2,292.000 32.0000

Remaining Qty To Pick Issued

Qty

Status

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	2292		*****
102552	6		
104248	6		
110507	184		
_111827	1102		32
113422	994		
15924	0		

W/O:			WC	RK ORDER CHA	NGES	· · · · · · · · · · · · · · · · · · ·			•	\$
DATE	STEP	PR	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No					NCR: Yes No DQA: Date:					
	Re:	solution:							Date:	
NCR:			WORK ORDE	ER NON-CONFOR	RMANCE	(NCR)				
DATE	STEP	Description of NC	Description of NC Section A Initial Action Descrip		Section B Sign &		Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	On	Date	Secti	on C	Chief Eng	QC Inspector
						,				
			1 1							

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IIN-D105-645 Page 4 of 4

4. WEIGHT AND BALANCE

	<u> </u>	LAT	ERAL.	LONGITUDINAL		
Installation	Weight	Arm	Moment	Arm	Moment	
D105-645-011 Bearpaw	13.8 lb	0.0 in	0.0 in-lb	148.7 in	2052.1 in-lb	
on Configuration 1/2	6.3 kg	0.0 m	0.0 m-kg	3.78 m	23.81 m-kg	
D105-645-011 Bearpaw	13.8 lb	0.0 in	0.0 in-lb	147.1 in	2030.0 in-lb	
on Configuration 3	6.3 kg	0.0 m	0.0 m-kg	3.74 m	23.56 m-kg	

5. PARTS LIST

Qty	Part Number	Description
Х	D105-645-011	BEARPAW INSTALLATION
[4	D2182B060 ,	RUBBER CUSHION
/3	D2274 ,	RADIUS BLOCK
7.2_	D2421 /	BEARPAW
14	D2519)	CLAMP
7 8	D2529/	WASHER
8ے	AN4-15A	BOLT
78	AN960JD416,	WASHER
<u>_8</u> _	MS21042L4 /	NUT (OR MS21042-4)

Revision: **B**

Date: 00.02.28

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W/O:		WORK ORDER CHANGES						• •		
DATE	STEP	PRO	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Category:			NCR: Yes No DQA:			Date:	
Resolution:			Disposition:		_ QA: N/C C	N/C Closed:		Date:		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)		,	- 81 · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC	Corrective Action Se		ion B	Sign & Verificati		Approval	Approval	
		Section A	Chief Eng	Chief Eng	Date		on C	Chief Eng	QC Inspector	
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				A A COLOR OF THE C						
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